

Work Order ID 67775

Wednesday, March 30, 2011 10:31:23 AM



Handwritten: End of this week April 1
Signature: [Signature]
 Page 1

Item ID: PB67-43001-157 Accept



Setup Start



Revision ID:

Item Name: Tube

Stop



Start Date: 3/30/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *UWX* Date: *11-03-30*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100 DOOSAN LATHE 0.00



Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA588 Rev: _____ & Dwg B67-43001-157 Rev: _____

2-Deburr per dwg B67-43001-157

Handwritten: 11/03/30

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Memo

0.00

Quality Control

Handwritten: 11/03/30

120 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

Handwritten: 11/3/30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: PB67-43001-157

Accept



Setup Start



Revision ID:

Item Name: Tube

Stop



Start Date: 3/30/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Memo

0.00

Small Fab

1- chamfer tube as per dwg

11/03/30

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.16/30

(+2)

150

Identify as per dwg & Stock Location: *446A*

0.00



Packaging

Memo

0.00

Packaging

11/3/30

20

W/O:		WORK ORDER CHANGES						
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Page 3

Item ID: PB67-43001-157

Accept

Setup Start

Revision ID:

Stop

Item Name: Tube

Start Date: 3/30/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/31

ME
11-03-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 10:31:20 AM

Page 1

Work Order ID: 67775



Parent Item: PB67-43001-157



Parent Item Name: Tube

Start Date: 3/30/2011

Required Date: 4/1/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A 05.07.20 New issue KJ/JLM
IPP Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.875W0.12 5		Purchased	No			100	f	36.0000	0.2583	0.543789			



6061-T6 RD TUBE .875 X .125W



Location

Loc Qty

Loc Code

MAT015

36

110001

36

.60 *JA* 11/03/30

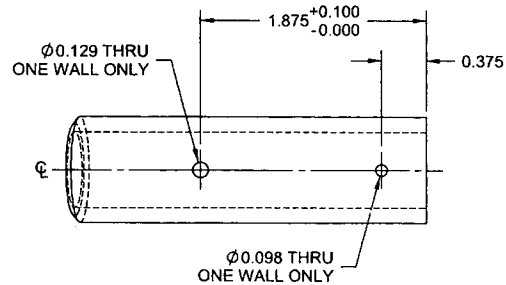
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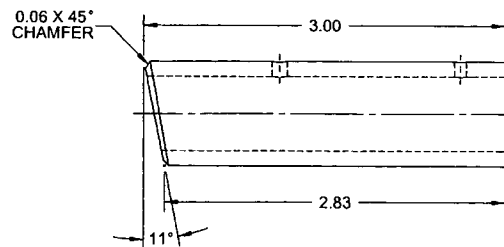
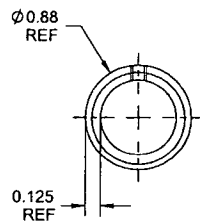
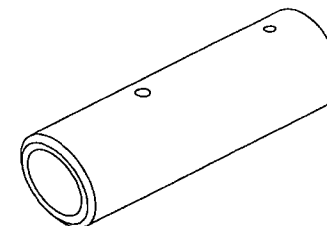
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NOTE: Date & initial all entries



#67775



B67-43001-157 TUBE

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T0.875W.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 35 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-157 TUBE <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	AS			
CHECKED	AS			
MFG. APPR.	AS			
APPROVED	N/A			
DE APPR.	N/A	REV. C SHEET 1 OF 1 SCALE NTS		
DATE	09.02.27			

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